

## CLAIMS

1. A method of providing stress relief in an elongated longitudinally curved panel having a central portion and at least one upstanding longitudinally extending side flange comprising the steps of:
  - 5 providing an elongated panel having a central portion and a longitudinally extending zone of material,
  - forming apertures in said longitudinally extending zone of said panel, bending said zone relative to said central portion, and
  - bending the panel longitudinally.
- 10 2. The method of claim 1 wherein said zone is bent relative to said central portion prior to the panel being bent longitudinally.
3. The method of claim 1 wherein said apertures are formed by punching the apertures in the panel.
4. The method of claim 1 wherein at least some of said apertures are  
15 closed.
5. The method of claim 4 wherein at least some of the apertures are open.
6. The method of claim 1 wherein said apertures have a shape selected from the group consisting of V-shaped, Y-shaped, X-shaped, U-shaped, W-shaped, M-shaped, triangular-shaped, diamond-shaped and half-moon crescent shaped.
- 20 7. The method of claim 1 wherein said zone is bent to be perpendicular to said central zone.
8. The method of claim 7 wherein there are two zones, one on either side of said central zone.
9. The method of claim 1 wherein said central portion intersects with said  
25 zone along a line of intersection and said line of intersection is curved in a longitudinally extending direction.
10. The method of claim 1 wherein said panel is bent with rollers.